

Work Order ID 55612

January 25, 2010 12:46:07 PM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

10

Start Date: 1/25/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/01/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *pl*

Date: 10-1-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2530

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536
2-Deburr

⇒ m-1 10/01/04

10X

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Sidelox

10

120

Weld per dwg A/R S.S. rod Batch: M109213 0.00

0.00



Small Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

10 PC 10/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

AD 10.02.08

(10)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8.10.12.108

(40)

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M105642

START TIME: 11:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:30AM

⇒ 11.10.10 10-02-09

(40)

✓

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 2/01/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-02-9 (10) ✓

170

Identify as per dwg & Stock Location: 506

0.00



Packaging

Memo

0.00

Packaging

10-2-9 (10) ✓

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10602/11 ✓

ME 10-2-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55612



Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 1/25/10

Required Date: 2/01/10

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

277.2810

18.4074



304 RD Tube .750 x .049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

277.281

107518

2.77

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

112652

44.89

112800

199.931

D2534

Manufactured

No

120

Each

19.0000

12.0000



Lock Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST017

19

52569

19

B55329

9
11

10/01/04

m-g

18.4074

lpd 10/02/04

W/O:		WORK ORDER CHANGES					
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DART

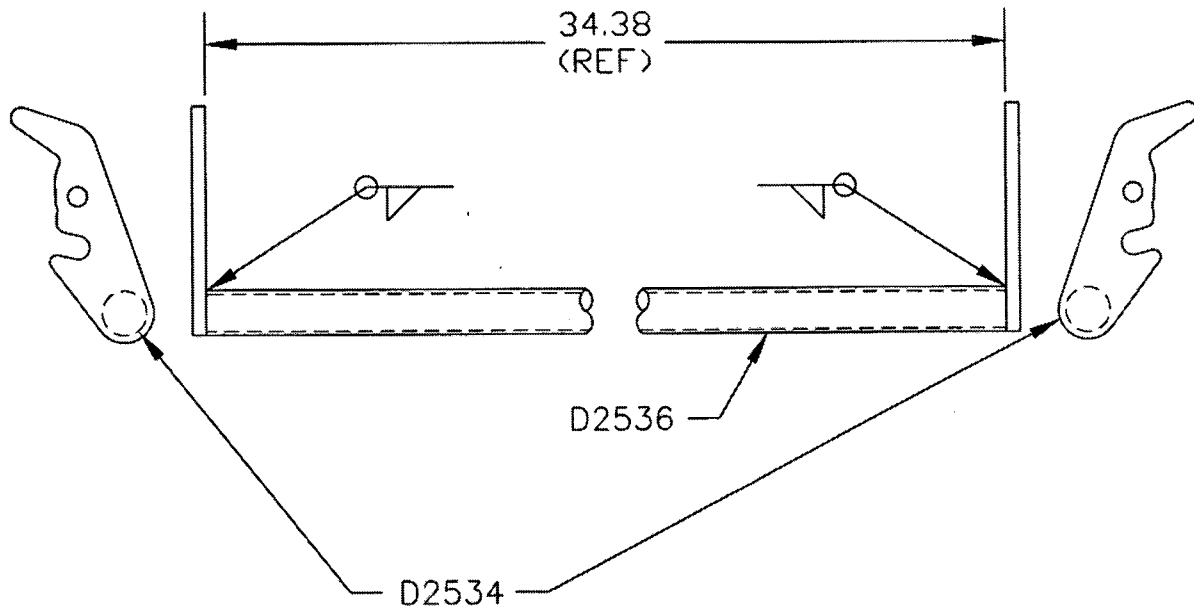
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2530	SHEET 1 OF 1
DATE		TITLE	
04.12.14		HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35612

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

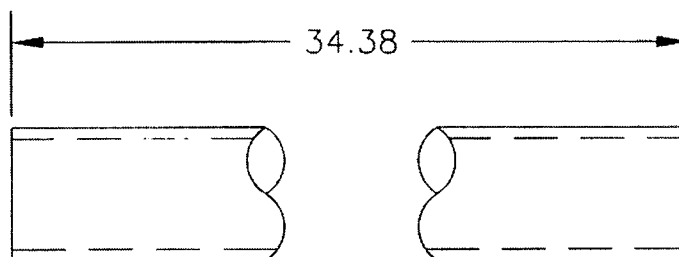


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH		
CHECKED #	APPROVED #	DRAWING NO. D2536	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE		SCALE NTS
A	96.05.15	NEW ISSUE	
B	04.12.14	UPDATE NOTES	

RELEASED

04.12.14 #

REFERENCE ONLY



D2536 HANDLE

- 1) MATERIAL: AISI 304/316 SS $\varnothing 0.75$ X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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